

Work Order ID 156998

Wednesday, February 08, 2017 10:19:21 AM

156998

Page 1

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Inboard Bracket Assembly
Start Date: 2/2/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/8/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: 8/3/2017 mf
31/3/2017
Approvals: Process Plan: **DAS 21 9-89** Date: FEB 14 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5076	A ✓								
110		0.00							
110						2	FF	MAR 08 2017	
Packaging	Memo	0.00							
Packaging									
120		0.00							
120						2	FF	MAR 08 2017	
Small Fab	Memo	0.16							
Small Fab	1-Assemble as per dwg, do not install grommets and rubber seal.								
130	QC5- Inspect part completeness to step on W/O	0.00							
130						2			
QC	Memo	0.01							
Quality Control									

**DAS
38
9-89**

MAR 08 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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3M 1300 batch: M136812

2 of 17-03-28

2 FF MAR 28 2017

2 ~~FS~~ MAR 28 2017

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

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Work Order ID: 156998

156998

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/2/2017

Required Date: 2/8/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.04.01 PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4434-9		Manufactured	No			110	Each	5.0000	1	2			
D4434-9									**	DAS			
Bracket										30			MAR 07 2017

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5		B757091					
					155205	1							
					155970	4							

D4441-1		Manufactured	No				f	385.6840		1.56			
D4441-1									**				
Rubber Seal											FF		MAR 28 2017

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST422		136.304							
					<u>151347</u>	136.304				1.56			
				ST625		249.38							
					<u>151347</u>	249.38							

D4441-1		Manufactured	No				f	385.6840		1.1			
D4441-1									**				
Rubber Seal											FF		MAR 28 2017

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST422		136.304							
					<u>151347</u>	136.304				1.1			
				ST625		249.38							
					<u>151347</u>	249.38							

DQA: _____ Date: _____



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Root Cause			FAULT CATEGORY					
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Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/2/2017

Required Date: 2/8/2017

Start Qty: 2.00

Required Qty: 2.00

D4441-1 Manufactured No

f

385.6840

0.866

D4441-1

Rubber Seal

FF

MAR 28 2017

Location

Loc Qty

Loc Code

ST422

136.304

151347

136.304

0.866

ST625

249.38

151347

249.38

D4441-1 Manufactured No

f

385.6840

1.066

D4441-1

Rubber Seal

FF

MAR 28 2017

Location

Loc Qty

Loc Code

ST422

136.304

151347

136.304

1.066

ST625

249.38

151347

249.38

D5076-1 Manufactured No

110

Each

0.0000

DAS
130
9-89

2

MAR 07 2017

D5076-1

Bracket

B155895

D5076-3

Manufactured No

110

Each

4.0000

1

2

D5076-3

Bracket

DAS
30
9-89

MAR 07 2017

Location

Loc Qty

Loc Code

ST614

4

155244

4

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 3

Work Order ID: 156998

156998

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/2/2017

Required Date: 2/8/2017

Start Qty: 2.00

Required Qty: 2.00

D4435-041

Manufactured No

110

Each

9.0000

1

2

D4435-041

Bracket Assembly

DAS

30

2-89

MAR 07 2017

Location

Loc Qty

Loc Code

ST098

9

B155684②

155252

9

D4441-1

Manufactured No

f

385.6840

0.284

D4441-1

Rubber Seal

FF

MAR 28 2017

Location

Loc Qty

Loc Code

ST422

136.304

151347

136.304

0.284

ST625

249.38

151347

249.38

D4441-1

Manufactured No

f

385.6840

0.416

D4441-1

Rubber Seal

FF

MAR 28 2017

Location

Loc Qty

Loc Code

ST422

136.304

151347

136.304

0.416

ST625

249.38

151347

249.38

D4440-1

Manufactured No

160

Each

19.0000

1

2

D4440-1

Grommet

FF

MAR 28 2017

Location

Loc Qty

Loc Code

GA

19

157227

152234

6

153108

13

2

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

Wednesday, February 08, 2017 10:19:21 AM

Page 4

Work Order ID: 156998

Parent Item: D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

156998

D5076-043

Start Date: 2/2/2017

Required Date: 2/8/2017

Start Qty: 2.00

Required Qty: 2.00

AN525-832R6

Purchased

No

110

Each

161.0000

3

6

AN525-832R6

Screw

**

FF

MAR 2 8 2017

Location

Loc Qty

Loc Code

GA

94

m136787

94

6

ST328

67

m136044

67

MS20426AD3-3

Purchased

No

110

Each

4,444.000

14

28

MS20426AD3-3

RIVET

**

FF

MAR 0 8 2017

Location

Loc Qty

Loc Code

fg108

280

M134946

200

M135354

80

GA

1494

M135274

1494

28

ST312

2670

M135274

2670

MS20470AD4-3

Purchased

No

110

Each

2,290.000

15

30

MS20470AD4-3

Rivet, Universal Head

**

FF

MAR 0 8 2017

Location

Loc Qty

Loc Code

GA

1025

2193

131

m135536

894

30

ST310

1265

m135536

1265

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, February 08, 2017 10:19:21 AM

Work Order ID: 156998

156998

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/2/2017

Required Date: 2/8/2017

Start Qty: 2.00

Required Qty: 2.00

MS21075L08

Purchased

No

110

Each

149.0000

7

14

MS21075L 08

ANCHOR NUT

DAS

30

9.00

MAR 07 2017

Location

Loc Qty

Loc Code

GA

47

M136182

47

ST298

102

M135774

102

M136986

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :									